

## Work Order ID 52513



Page 1

September 29, 2009 10:47:26 AM

Item ID: D3065-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 29/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 43.00



Customer:

Reference:

Approvals: Process Plan: B1Date: 09-9-29

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3065	Rev B								<i>not not pullets</i>

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3065  Dwg Rev: B  Prog Rev: B  2-  
Deburr if necessaryBR 9-11-3

(49)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

BR 9-11-3

(Pb) -&gt;

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

2) Sortulay

(work)  
x48  
book  
x1  
Pm  
temples

WO: 52513		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
21/04	#120	Took Qly & Part for QC inspection Template		S	21/04	1		OS-11-05	S os 21/04

Part No: D3065-17 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 52513**

September 29, 2009 10:47:26 AM



Page 2

Item ID: D3065-7

Accepted



## Setup Start



Revision ID: B

Stop



**Start Date:** 29/09/2009 **Start Qty:** 40.00



**Cust Item ID:**

**Required Date:** 06/10/2009    **Req'd Qty:** 40.00



**Customer:**

### **Reference:**

## Run Start



### **Approvals:**      **Process Plan:**

**Date:** \_\_\_\_\_

## Tooling:

**Date:** \_\_\_\_\_

Gutmann

QC:

Date: \_\_\_\_\_

**SPC (Y/N)**

**Date:** \_\_\_\_\_

A standard linear barcode is located at the bottom of the page, consisting of vertical black bars of varying widths on a white background.

**Work Order ID 52513**

September 29, 2009 10:47:26 AM



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Item ID: D3065-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 29/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Chemical Conversion Coat per QSI005 4.1

0.00

M 09/11/10

48x ✓

HandFinish

Memo

0.00

Hand Finishing

170



QC3- Inspect Part Finish

0.00

MD 09/11/10

X48

QC

Memo

0.00

Quality Control

180



Identify as per dwg &amp; Stock Location: GA

0.00

Packaging

Memo

0.00

Packaging

**Work Order ID 52513**

Page 4

September 29, 2009 10:47:26 AM

Item ID: D3065-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 29/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/11/10

MF

09-11-10

**Picklist Print**

Page 1

September 29, 2009 10:47:25 AM

Work Order ID: 52513



Parent Item: D3065-7RevB



Parent Item Name: Step Spacer

Start Date: 29/09/2009

Required Date: 06/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	220.2565	6.6274	8.1185		

2024-T3 .040 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

MAT	220.2564789	
110337	6.4	
111786	39.0665789	
112291	91.9258	
112331	82.8641	

143004

113004

(49)

113004

DART AEROSPACE LTD	Work Order:	52613
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

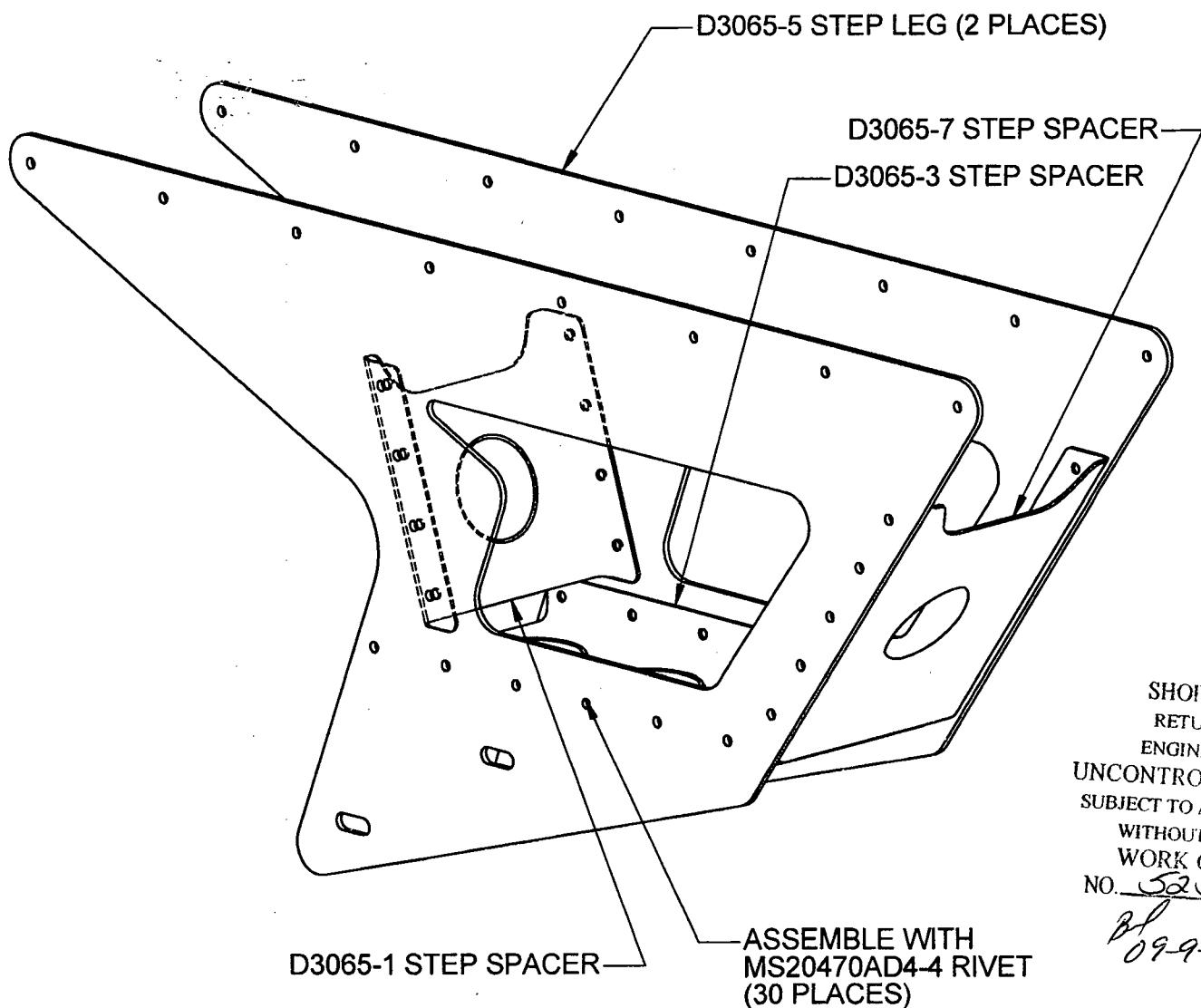
## X First Article      Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-3	Date:	07/4/04	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED***06.06.20 [Signature]*

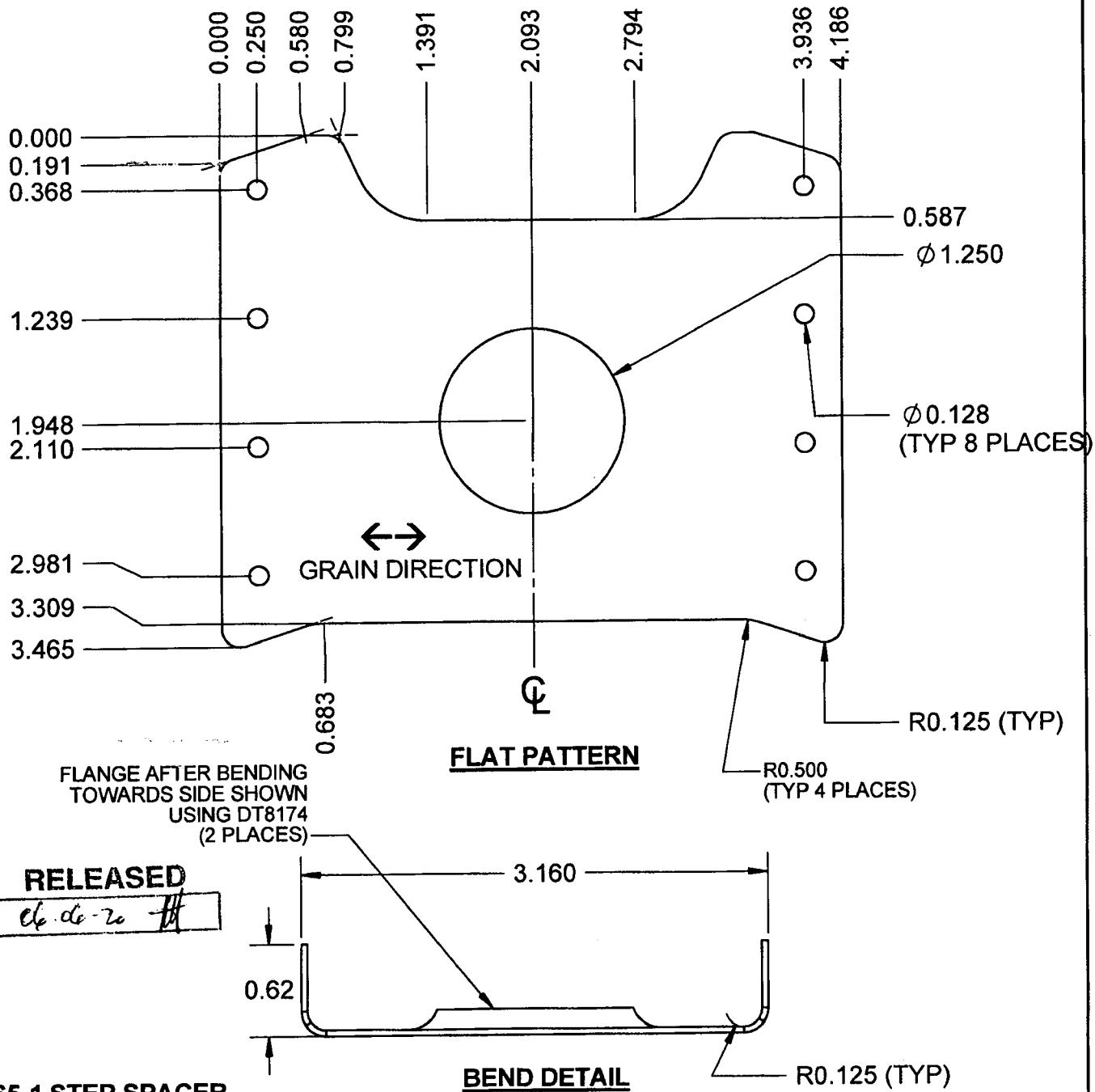
## D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

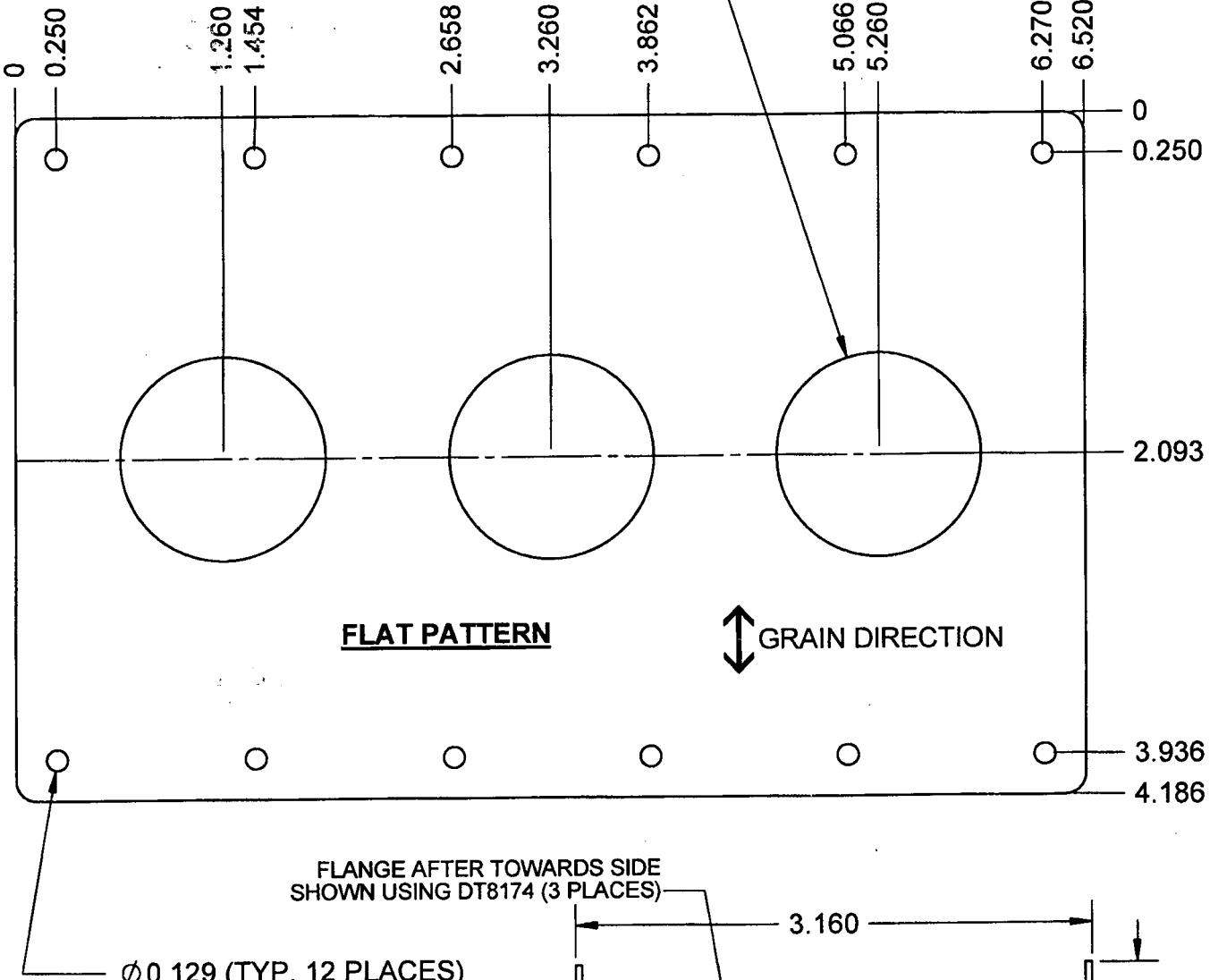
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

$\phi 1.250$  (TYP, 3 PLACES)



### D3065-3 STEP SPACER

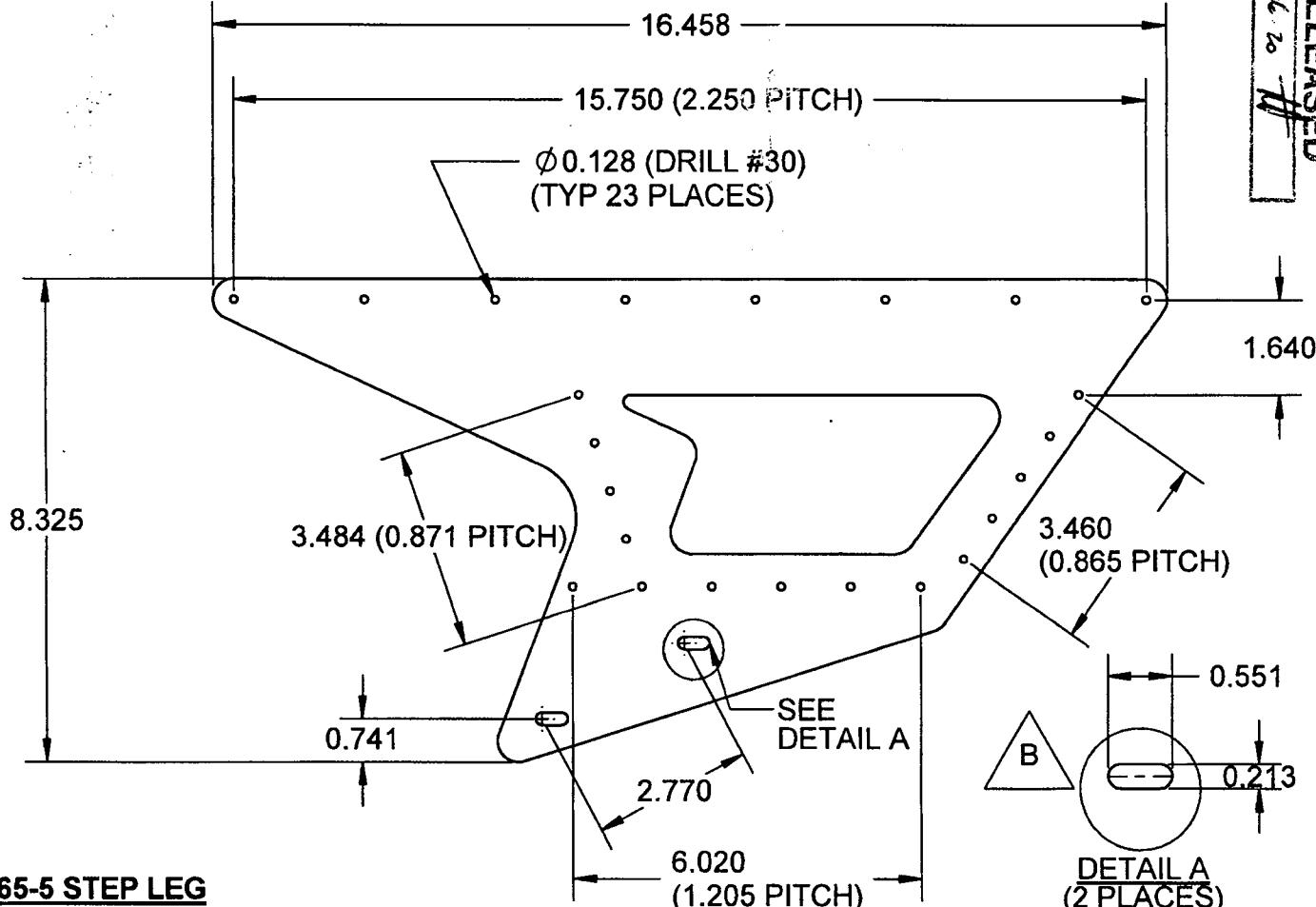
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

DESIGN <i>10</i>	DRAWN BY <i>C.B.</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P.H.</i>	APPROVED <i>J.W.</i>	DRAWING NO. <b>D3065</b>
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>	REV. B SHEET 4 OF 5 SCALE <i>1:3</i>

**RELEASED**  
*06.06.23 - H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

W/O 52513



DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

